



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-111-107

Job Sheet 201269



Part No: RB T102137-111-107

Job Qty: 6 pcs

Part Name: Sleeve



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Due Date: 10/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T102137-111 Rev B IPP Rev. A 19.06.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	SL-154 - 1	6 pcs	10/28/19	10/28/19	1.00	0.30	SL-154 - 1	JB 19-10-25
120	QC 2	6 pcs	10/28/19	10/28/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-10-25
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S226278

Part: RB T102137-111-107

Job No: 201269

Serial No/Batch: S226278

Revision: B

Inspector:

Exp Date:

9/30/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130 QC 8	6 pcs	10/28/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
131 QC 5	6 pcs	10/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
132 Outsource - 1 - Heat Treat	6 pcs	10/28/19		MEI001-VC ATCOZ 12	2019-10-28
133 Packaging 2-1 - Receive - B4B	6 pcs	10/28/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	

19/10/25

2019-10-28

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				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
134 QC 6	6 pcs	10/28/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
140 Packaging 3-1 - Stock - B4B	6 pcs	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

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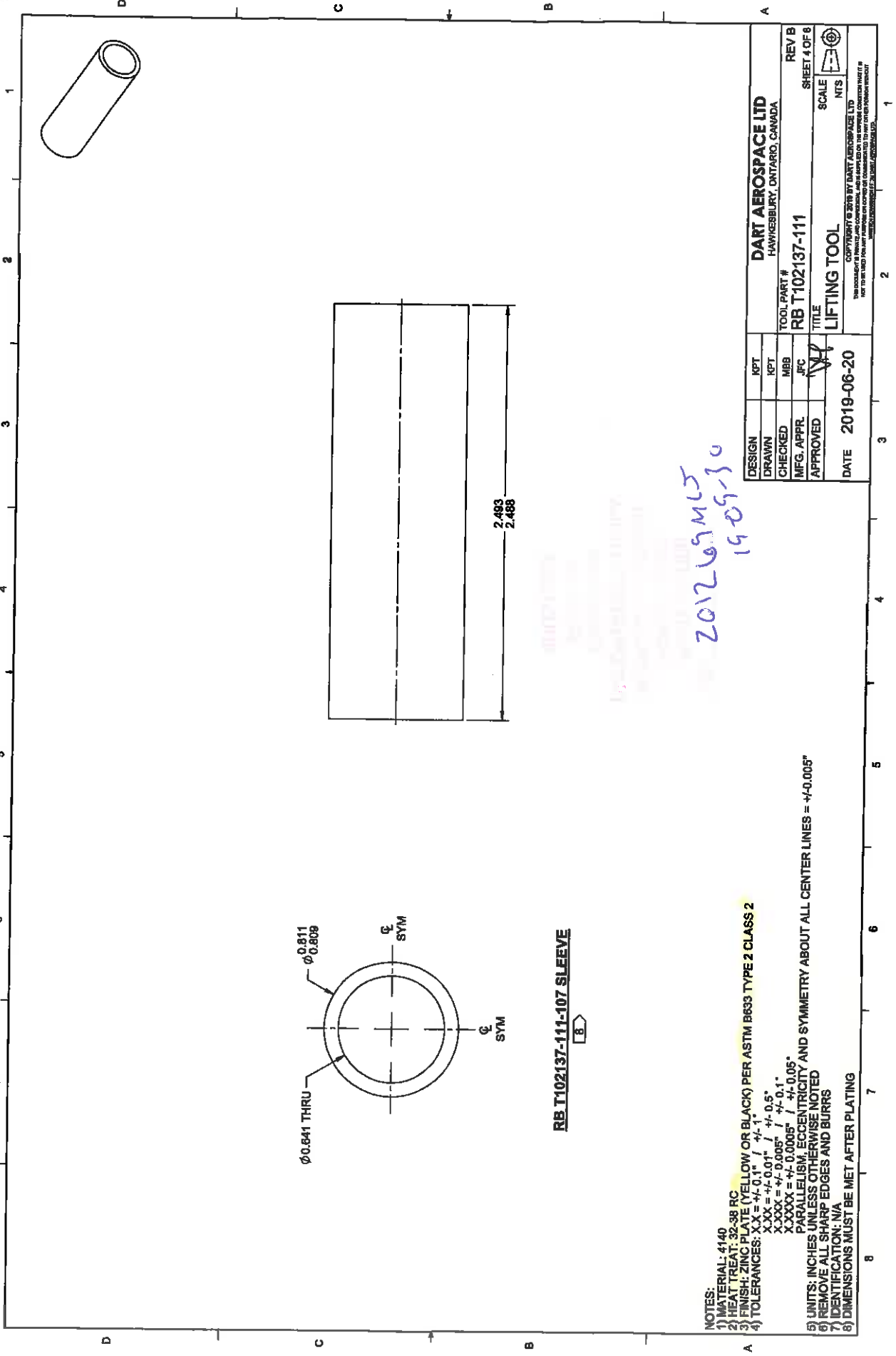
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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	6 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - MORI SL-154 LATHE - 1-Machine as per folio. FD 041 ***NOTE*** Same as RB T102137-107-107 FB845*** Descriptions: FOLIO REV: <u>AA</u> DWG REV: <u>B</u> 2-Debur 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 131 - QC5- Inspect part completeness to step on W/O 132 - 1-Issue P/O; <u>44918</u> Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required 133 - Receive & Inspect for Damage & Mat'l Certs 134 - QC6- All purchased or subcontracted products ***NOTE*** Zinc plating to be done after load test at final assembly. 140 - Identify as per dwg & Stock Location: _____ 150 - Identify as per dwg & Stock Location: _____					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M4140N-R0.875	4140 Steel Round Bar 0.875"	1.3500 ft (.225 ea)	110-SL-154 - 1	<u>S044297</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-SL-154 - 1	M4140N-R0.875	1	14	0	
Part Specifications					
Specifications could not be found.					

Plex 9/30/19 10:36 AM Dart.lajeunesse.marie



NOTES:

- 1) MATERIAL: 4140
- 2) HEAT TREAT: 32-38 RC
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES:
XX = ± 0.1 , ± 1
XXX = ± 0.005 , ± 0.5
XXXX = ± 0.005 , ± 0.1
XXXXX = ± 0.005 , ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	KPT	
CHECKED	MBB	
MFG. APPR.	JFC	
APPROVED	W	TOOL PART # RB T102137-111
DATE	2019-06-20	TITLE LIFTING TOOL
		SCALE NTS
		REV B SHEET 4 OF 8

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044918



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866-257 6395

Attention: Ananthi Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044918

PO Date: 10/28/19

Due Date: 11/5/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200885	RBA9829-3	RBA9829 Rev 3	Wrench 1-Issue P/O Heat treat RC 35-40 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type 4140 5-Certificate of Conformity is required	Firmed	-	11/5/19	5 pcs	0 pcs	5 pcs	\$16.00/pcs	\$80.00
2	201268	RB T102137-11-105	RB T102137-111 Rev B	Pin 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/5/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00
3	201269	RB T102137-11-107	RB T102137-111 Rev B	Sleeve 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/5/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00

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PURCHASE ORDER POHB044918



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199904	RBW6405G12031-3G-7	RBW6405G12031-3G Rev 3	Pull Stud 1-Issue P/O RC 34-38 2-Bead blast 3-Material type 4140 4- Certificate of Conformity is required	Firmed	-	11/5/19	8 pcs	0 pcs	8 pcs	\$12.87625/pcs	\$103.01
Line Item Note 3 bars = 8 cut pieces once heat treated and we cut											Grand Total	\$343.01

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/31/19 10:14 AM Dart,Guern, Kimberley

Atlantic Heat Treating (2001) Ltd

Order No.: 171448

Ship Date: 30/10/2019

Shipping Ticket

Sold To: 1448DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 168260DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

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Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB044918				

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

6 PCS MATERIAL 4140
BEAD BLAST AND HEAT TREAT TO 32-38RC
C OF C, PRT# RB T102137-111-107, JOB# 201269

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 6

Pounds Shipped: 1.00

RECEIVED

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DART AEROSPACE LTD.

38RC

10-1-19

Order No.: 171448

Shipped Complete

Quantity Shipped: 6.00

Received By: Date:

Pounds Shipped: 1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 10/30/2019

Certification

Date: 10/31/2019

Entry Date: 10/30/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB044918

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6 PCS MATERIAL 4140 BEAD BLAST AND HEAT TREAT TO 32-38RC C OF C, PRT# RB T102137-111-107, JOB# 201269	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					
Harden rockwell					

Results:

Harden ROCKWE 32. 38. 38. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 38 RC AS PER CUSTOMER REQUEST

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STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OR CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

per Joe Buggy
RICK BUGGY
QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD